

**Work Order ID 71138**

Thursday, June 23, 2011 12:31:53 PM



Page 1

Item ID: D3443-041

Accept



Setup Start



Revision ID:

Item Name: Strut Weldment Assembly

Stop



Start Date: 6/23/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: JMF

Date: 11-06-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3443	Rev C

100	Large Fab	0.00
	Memo	0.00
Large Fab	Weld assembly as per dwg D3443	

EZ 11-9-6 X6

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
	Memo	0.00
QC	Weld assembly as per dwg D3443	

RPL 11-06-06 X6

120	QC5- Inspect part completeness to step on W/O	0.00
	Memo	0.00
QC	S11-06-06	
Quality Control		

G6

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



Powdercoat

Powder Coating

140



QC

Quality Control

150



Small Fab

Small Fab

Operation  
Description

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Memo

0.00

1-Mask holes as per dwg D3443

START TIME: 7:30OVEN TEMPERATURE: 400 °FFINISH TIME: 8:00

M117146

QC3- Inspect Part Finish

0.00

Memo

0.00

6x Ø M-L 11/09/07

6 Ø M 11/09/07

Small Fab

0.00

Memo

0.00

Assemble bearing and ball plungers as per dwg D3443 using DT9518

Ensure bearing rotates smoothly

E5u/08/07 (6)

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Stop



Start Date: 6/23/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC5- Inspect part completeness to step on W/O

0.00

SB 11/09/07

(6)

Quality Control

170



Identify as per dwg &amp; Stock Location: SF

0.00

Memo

w/o 70159 (1)

w/o 71988(2)

w/o 71990(2)

Packaging

Packaging

SB 11/09/07 0

(6)

180



QC21- Final Inspection - Work Order Release

0.00

Quality Control

Memo

0.00

11/09/07

MF  
(1-09-07)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

## Picklist Print

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Page 1

Work Order ID: 71138



**Parent Item:** D3443-041



**Parent Item Name:** Strut Weldment Assembly

**Start Date:** 6/23/2011

Required Date: 7/12/2011

Comments: IPP REV. A 05.11.17 NEW ISSUE ECR

Start Oty: ?

**Start Qty:** 2.00

Required Qty: 2.00

**Required Qty:** 2.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

Page 2

Thursday, June 23, 2011 12:31:51 PM

Work Order ID: 71138



Parent Item: D3443-041



Parent Item Name: Strut Weldment Assembly

Start Date: 6/23/2011

Required Date: 7/12/2011

D3966-4-750

Manufactured No

100

Each

44.0000

2

4



EL 11-9-2

Pin, Dowel



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST100 58711	44 44	<u>12</u>

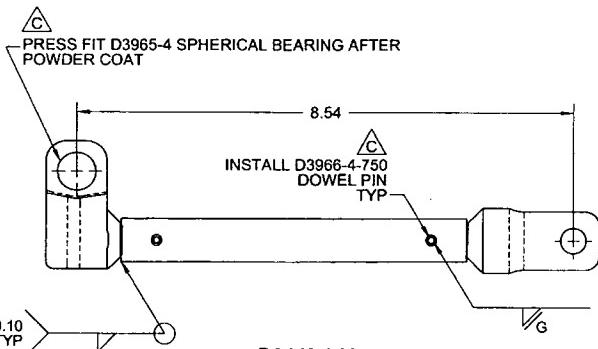
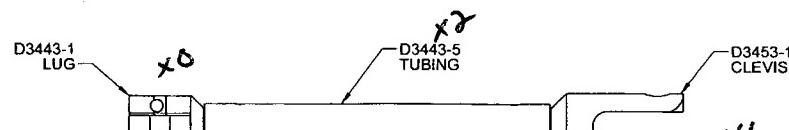
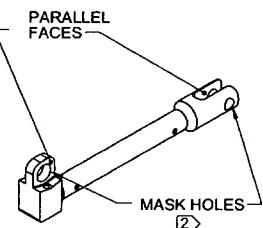
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL



- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
NO POWDER COAT IN HOLES
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 1.33 lbs
  - 8) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN A8-1, A8-2) 0.820 WAS 0.720 & 1.43 WAS R0.040 (ZN C2-3) 0.551 WAS 0.451 (ZN C1-3) R0.219 WAS R0.040 (ZN C2-3) 0.393 WAS 0.300 (ZN C1-3) R0.199 REMOVED PLUNGER PIN (ZN C8-1, BS-1), REF PAR 09-018			RF	09.06.25
B	ADDED -9 PIN, REMOVED BALL PLUNGER; REVISE TOLERANCE, & Ø0.125 WAS #30			RF	05.12.05
A	NEW ISSUE			RF	05.09.02
REV.	DESCRIPTION	DESIGN	RF	DART AEROSPACE LTD HAWKSLEY, ONTARIO, CANADA	
	DRAWN	RF		DRAWING NO.	REV. C
	CHECKED	GJ		D3443	SHEET 1 OF 4
	MFG. APPR.			TITLE	SCALE
	APPROVED			STRUT WELDMENT ASSEMBLY	NTS
	DE APPR.				
	DATE	09.06.25			

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RELEASED  
09/06/2005

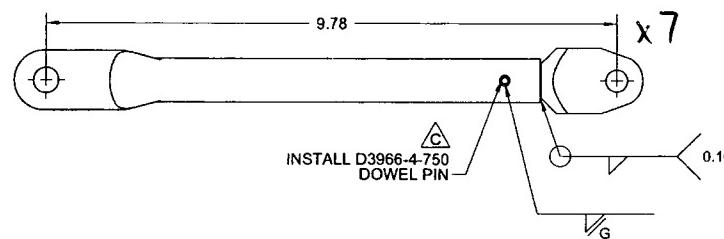
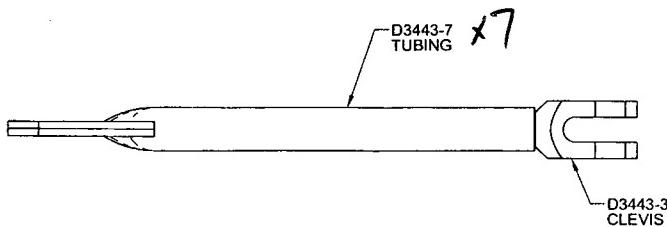
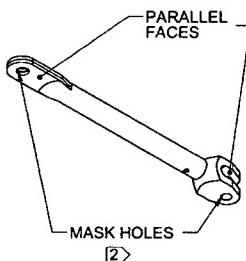
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ITEM	QTY	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



#71138

RELEASED  
07/07/25/14

D3443-043

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3443	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STRUT WELDMENT ASSEMBLY	
DATE	09.06.25	NTS	

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8 7 6 5 4 3 2 1

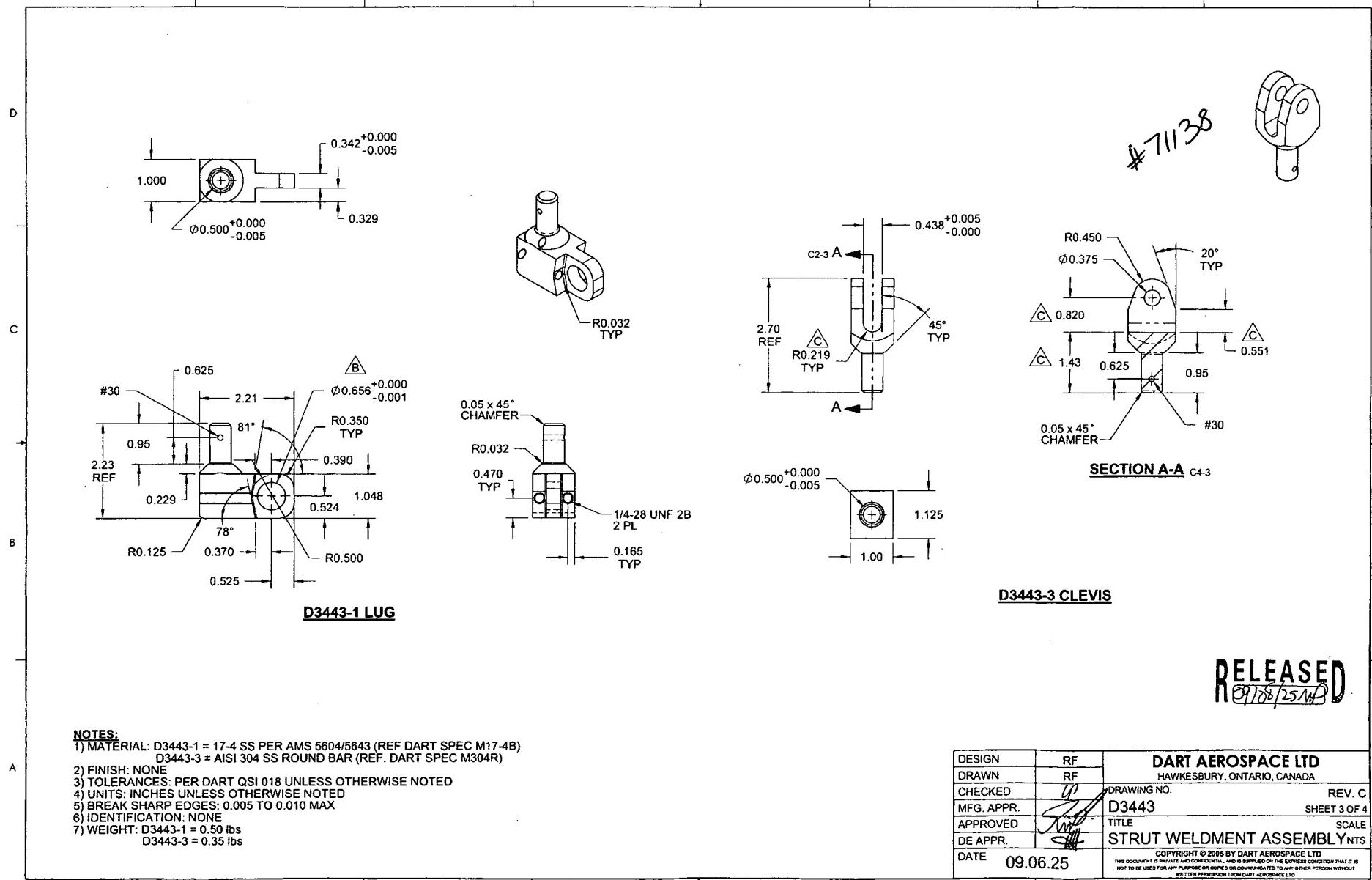
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8 7 6 5 4 3 2 1



DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[initial]</i>	DRAWING NO.	
MFG. APPR.	<i>[initial]</i>	REV. C	
APPROVED	<i>[initial]</i>	D3443	
DE APPR.	<i>[initial]</i>	SHEET 3 OF 4	
DATE	09.06.25	TITLE	STRUT WELDMENT ASSEMBLY NTS

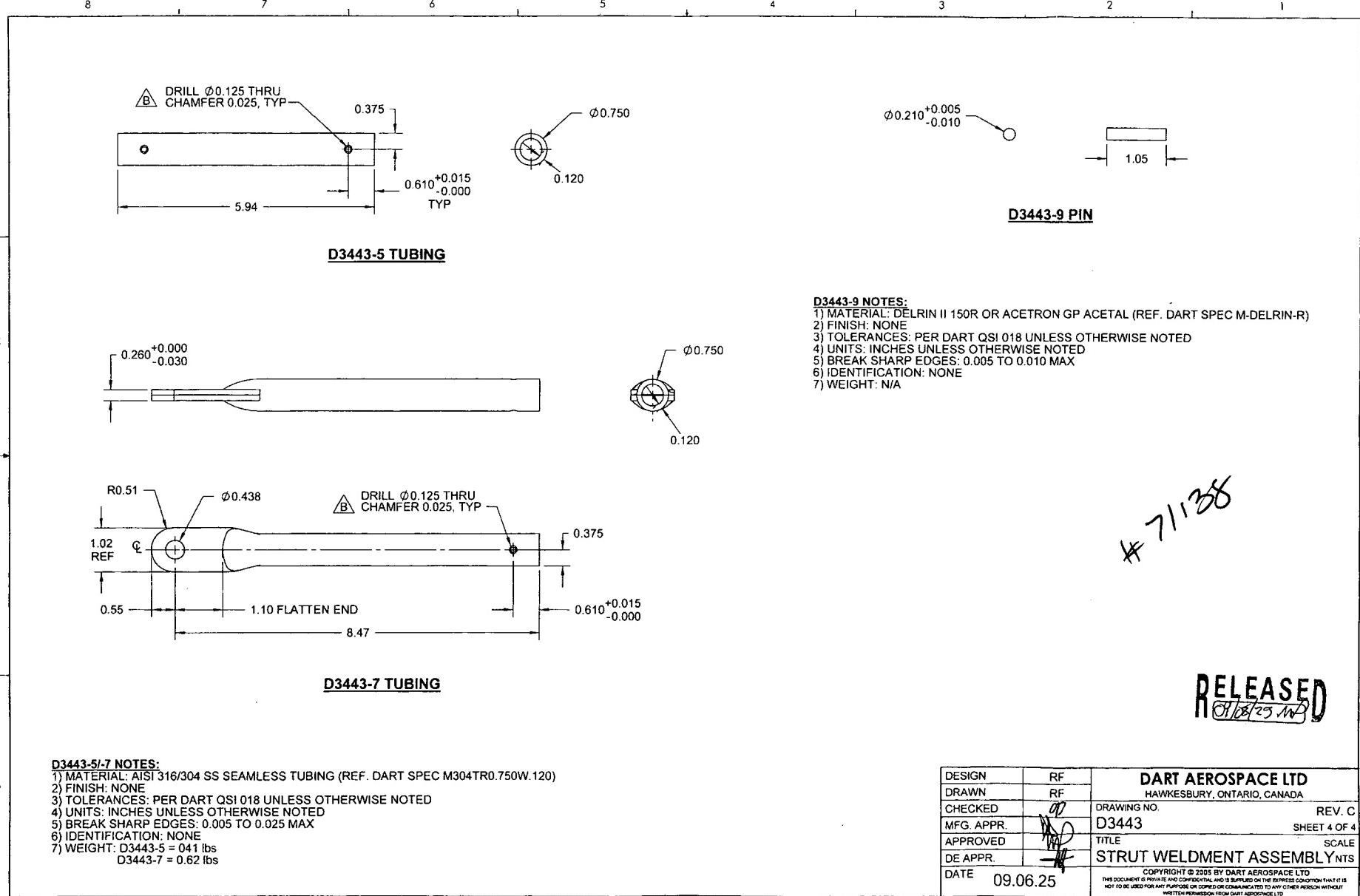
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